

Work Order ID 70181

Monday, May 30, 2011 3:18:10 PM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-05-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 6/1/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.
A/R ☐ Sikaflex-241/-291 11117516
Expiry date: 06/15

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 11117516
Expiry date: 06/15

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
A/R ☐ LPS Procyon 11114596

1 6 11 117516 06/15

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Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sub 6/22

(to)

130



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev:

PPP 70182

11/6/22 (1)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/6/22 (1)

ME 11-06-22

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Picklist Print

Monday, May 30, 2011 3:18:07 PM

Page 1

Work Order ID: 70181

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube



Start Date: 6/1/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			110	Each	2,337.000	24	24			
BOLT													

Location	Loc Qty	Loc Code
ST350	2337	
117094	955	
117313	82	
117688	800	
117795	500	

X24

11/06/21

AN3C6A 		Purchased	No			110	Each	362.0000	12	12			
BOLT													

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	361	
111982	2	
116419	23	
116549	50	
116704	36	
117514	100	
117619	50	
117688	100	

X12

11/06/22

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Page 2

Work Order ID: 70181

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 6/1/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C7A

Purchased

No

110

Each

183.0000

8

8



BOLT



48 110612

Location

Loc Qty

Loc Code

ST351

165

113149

14

116169

9

117313

92

117688

50

ST352

18

117619

18

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

44

44



washer

M117887



370178(x1)(x44) 110612

D3391-021

Manufactured

No

110

Each

0.0000

1

1



Fwd Tube Assembly

D3391-023

Manufactured

No

110

Each

0.0000

1

1



Mid Tube Assembly

D3391-025

Manufactured

No

110

Each

1.0000

1

1



Aft Tube Assembly



370500(x1) 110612

Location

Loc Qty

Loc Code

FP

1

48122

1

Monday, May 30, 2011 3:18:07 PM

Shop Packet Print

Page 2

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Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 6/1/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-1



Wearshoe

Manufactured No

110

Each

9.0000

1

1



Handwritten: 11/06/11

Location

Loc Qty

Loc Code

FG

2

33798

2

FP019

7

64747

7

Handwritten: x1

D3564-3



Wearshoe

Manufactured No

110

Each

12.0000

1

1



Handwritten: 11/06/11

Location

Loc Qty

Loc Code

FG

2

33764

2

FP019

10

64748

3

66000

4

69290

3

Handwritten: x1

D3564-5



Wearshoe

Manufactured No

110

Each

20.0000

1

1



Handwritten: 11/06/11

Location

Loc Qty

Loc Code

FG

2

34806

2

FP019

18

68960

18

Handwritten: x1

W/O:		WORK ORDER CHANGES					
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Page 4

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Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 6/1/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-1



Gasket

Manufactured No

110 Each

46.0000

2

2



11/06/21

Location

Loc Qty

Loc Code

FP015

46

68924

24

69279

22

D3566-5



Gasket

Manufactured No

110 Each

34.0000

1

1



11/06/21

Location

Loc Qty

Loc Code

FP015

34

67589

1

68961

33

11/06/21

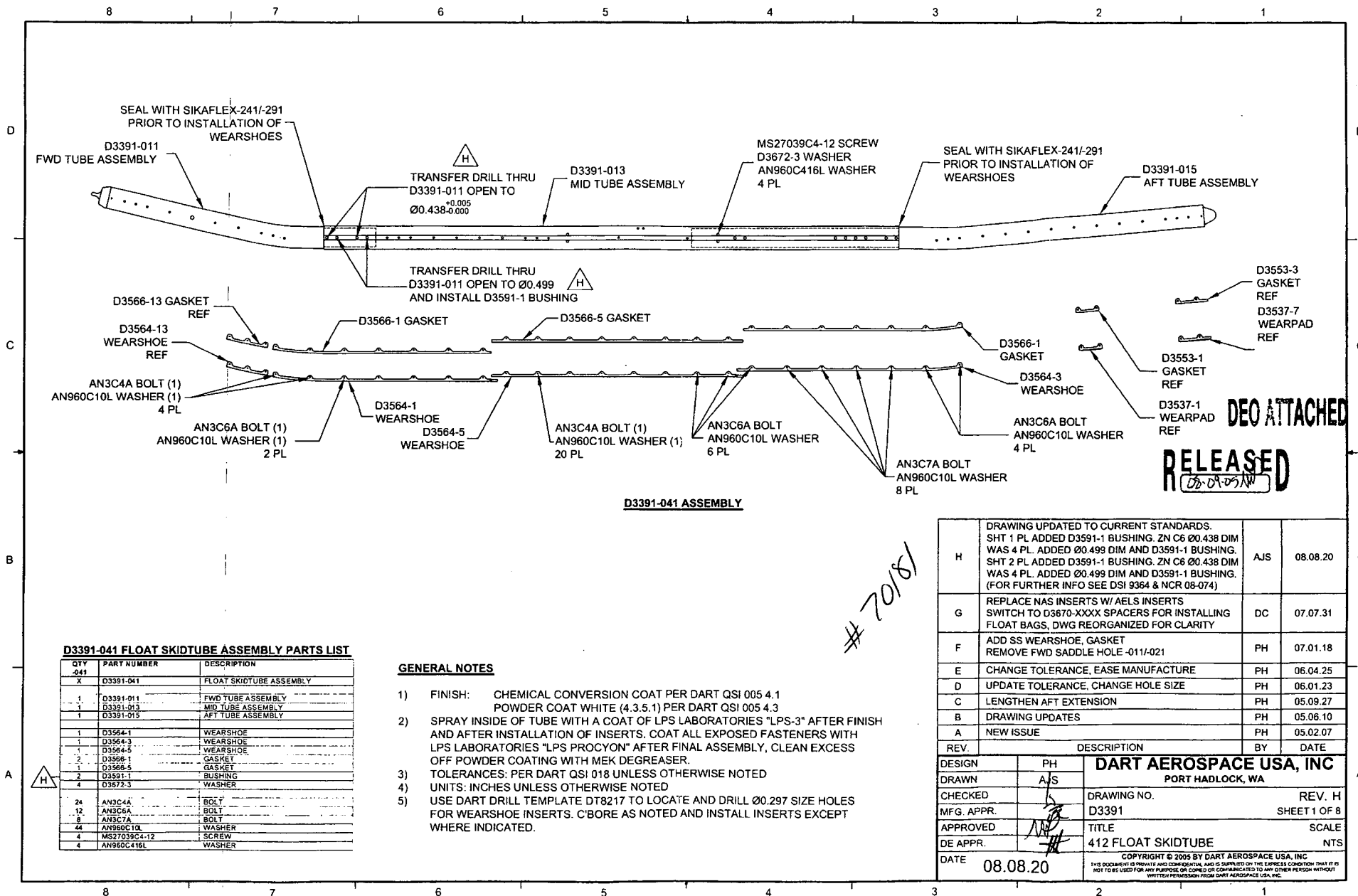
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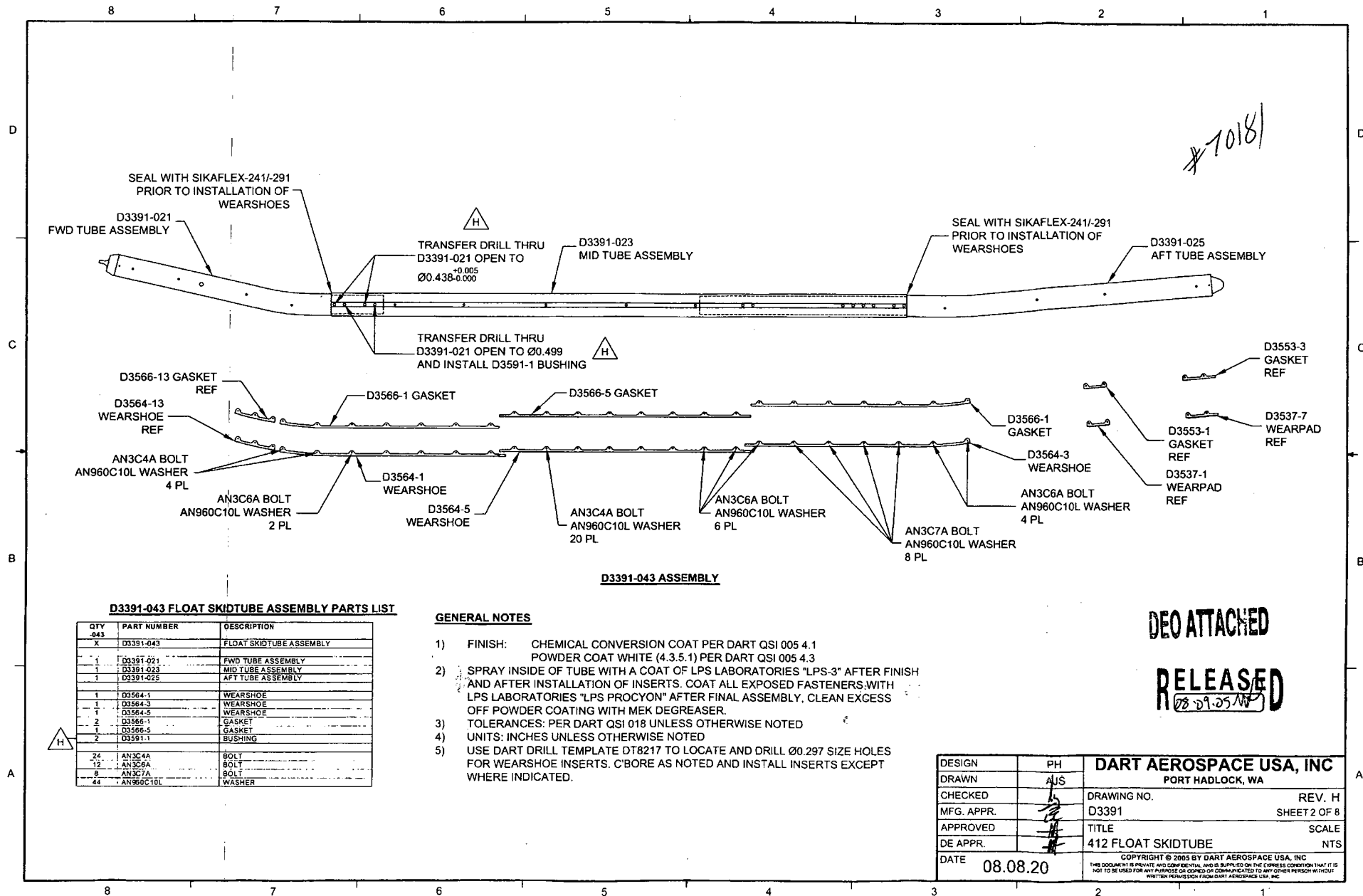
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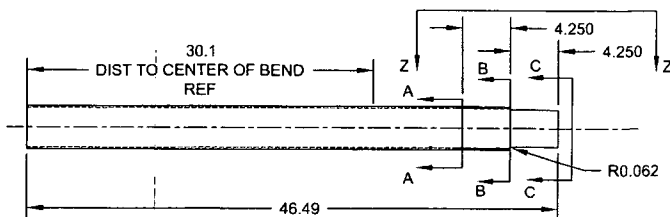
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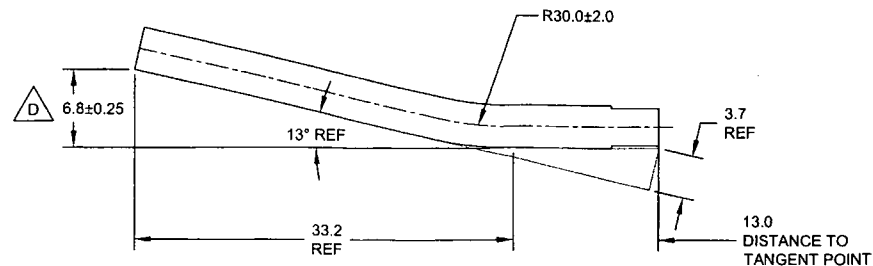
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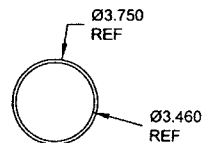
NOTE: Date & initial all entries



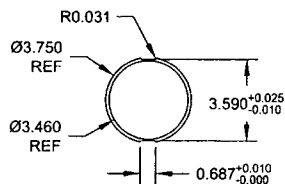
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



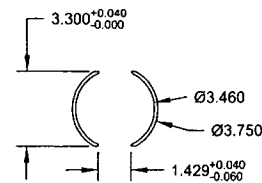
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



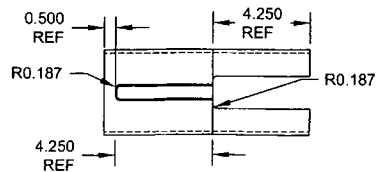
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H SHEET 3 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		412 FLOAT SKIDTUBE	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
DATE	08.08.20	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

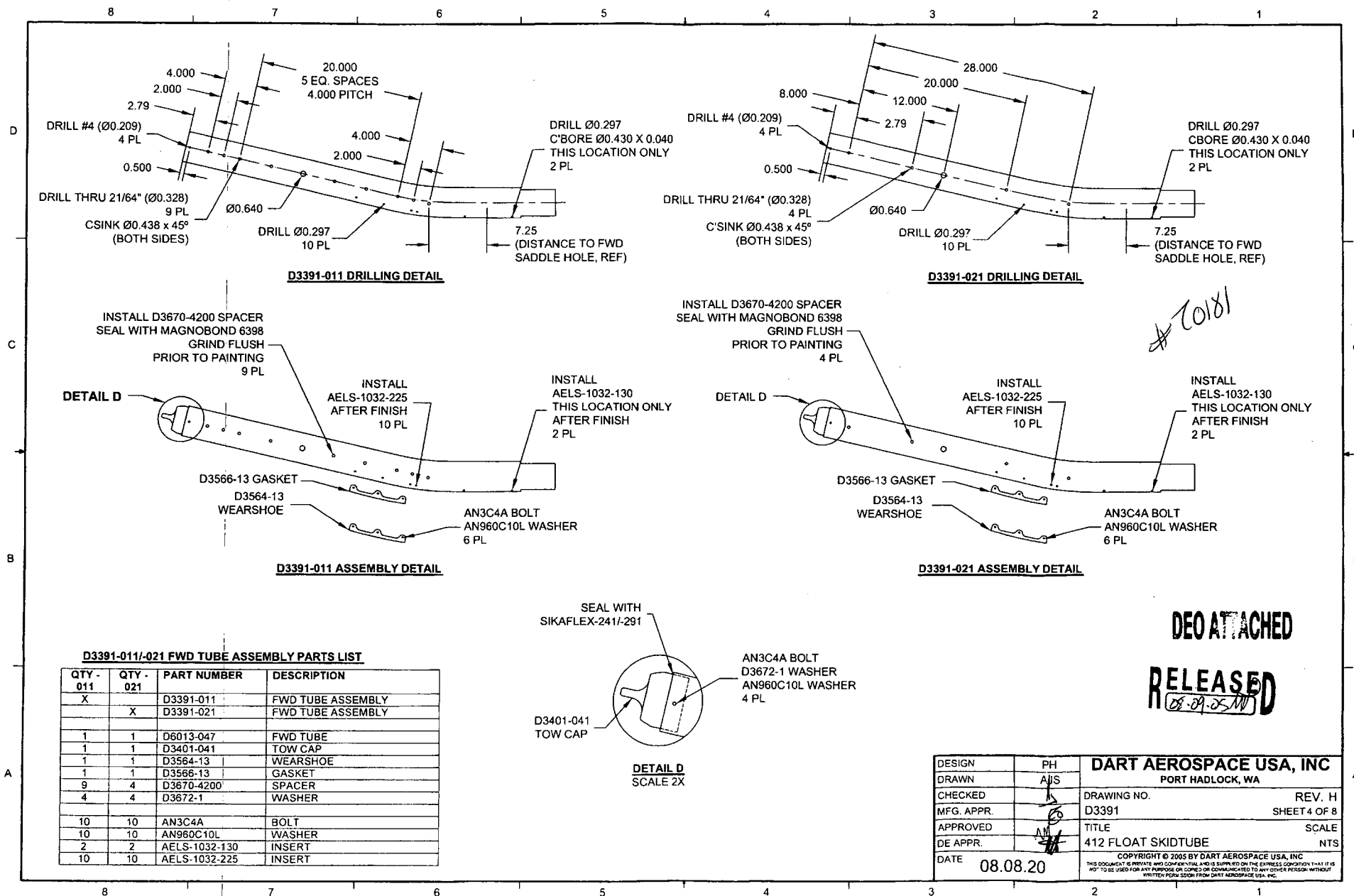
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Dart Aerospace Ltd

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NOTE: Date & initial all entries

8

7

6

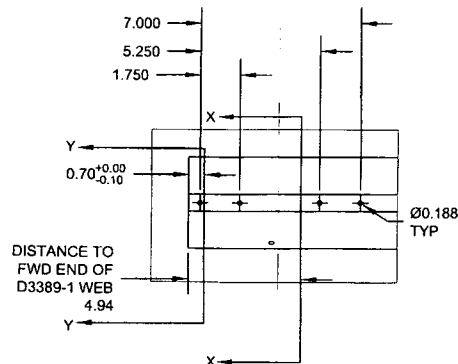
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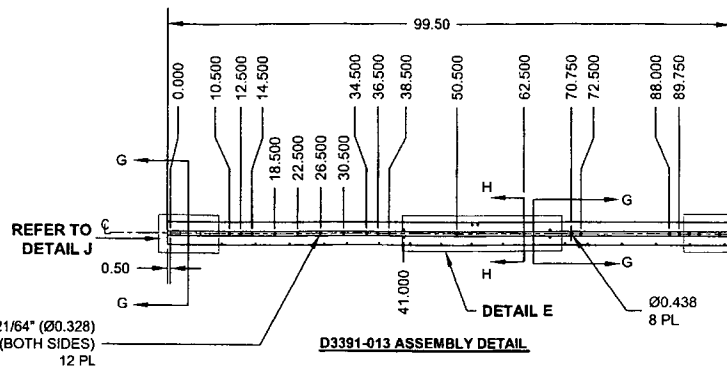
2

1



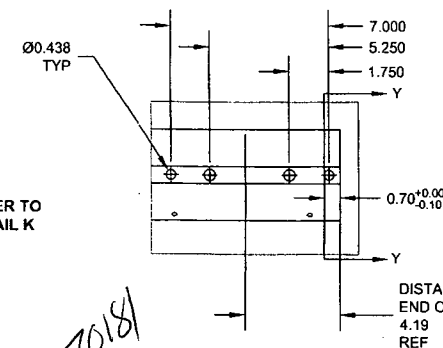
DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



D3391-013 ASSEMBLY DETAIL

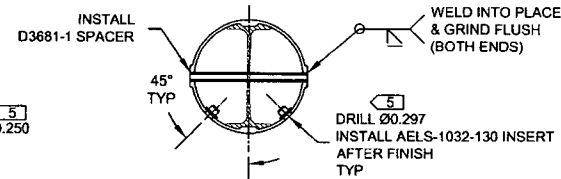
REFER TO
DETAIL K



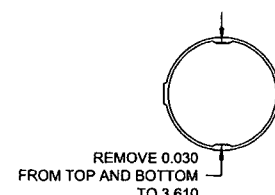
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SCALE 4X



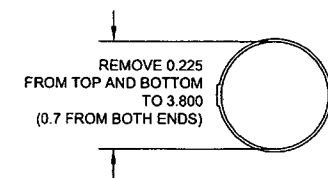
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



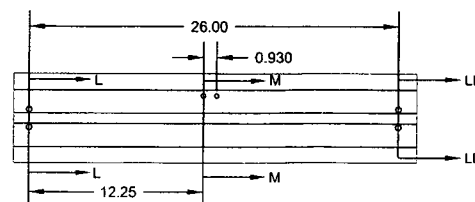
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

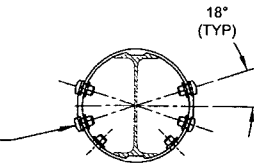
D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- WELDING: PER DART QSI 004

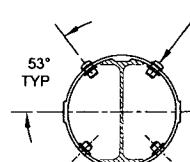


DETAIL E
SCALE NONE

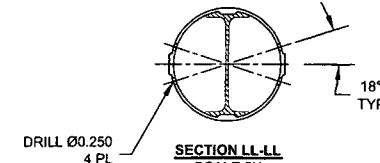
DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



SECTION L-L
SCALE 5X







SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X

DEO ATTACHED

RELEASED

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

Dart Aerospace Ltd

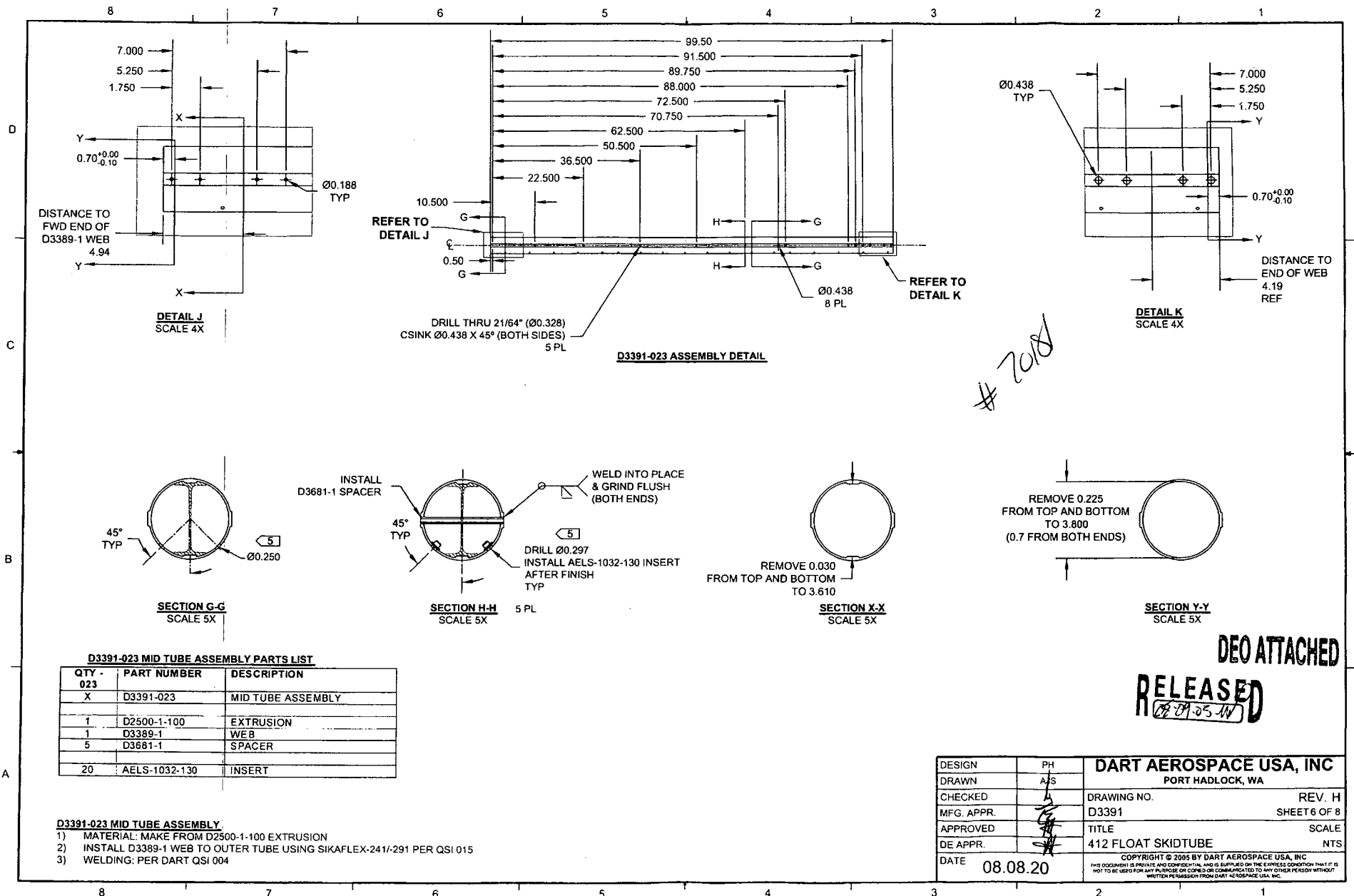
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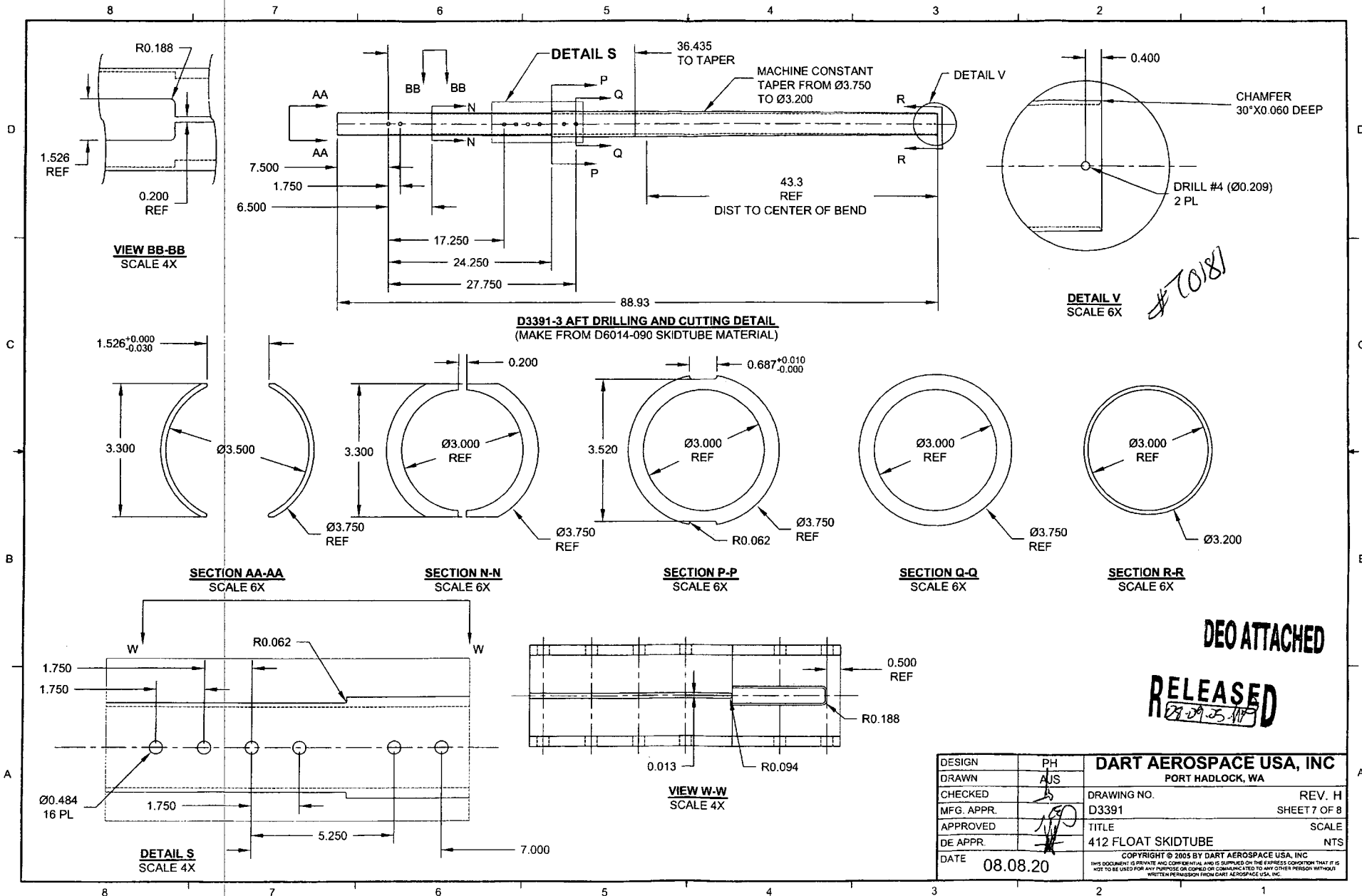
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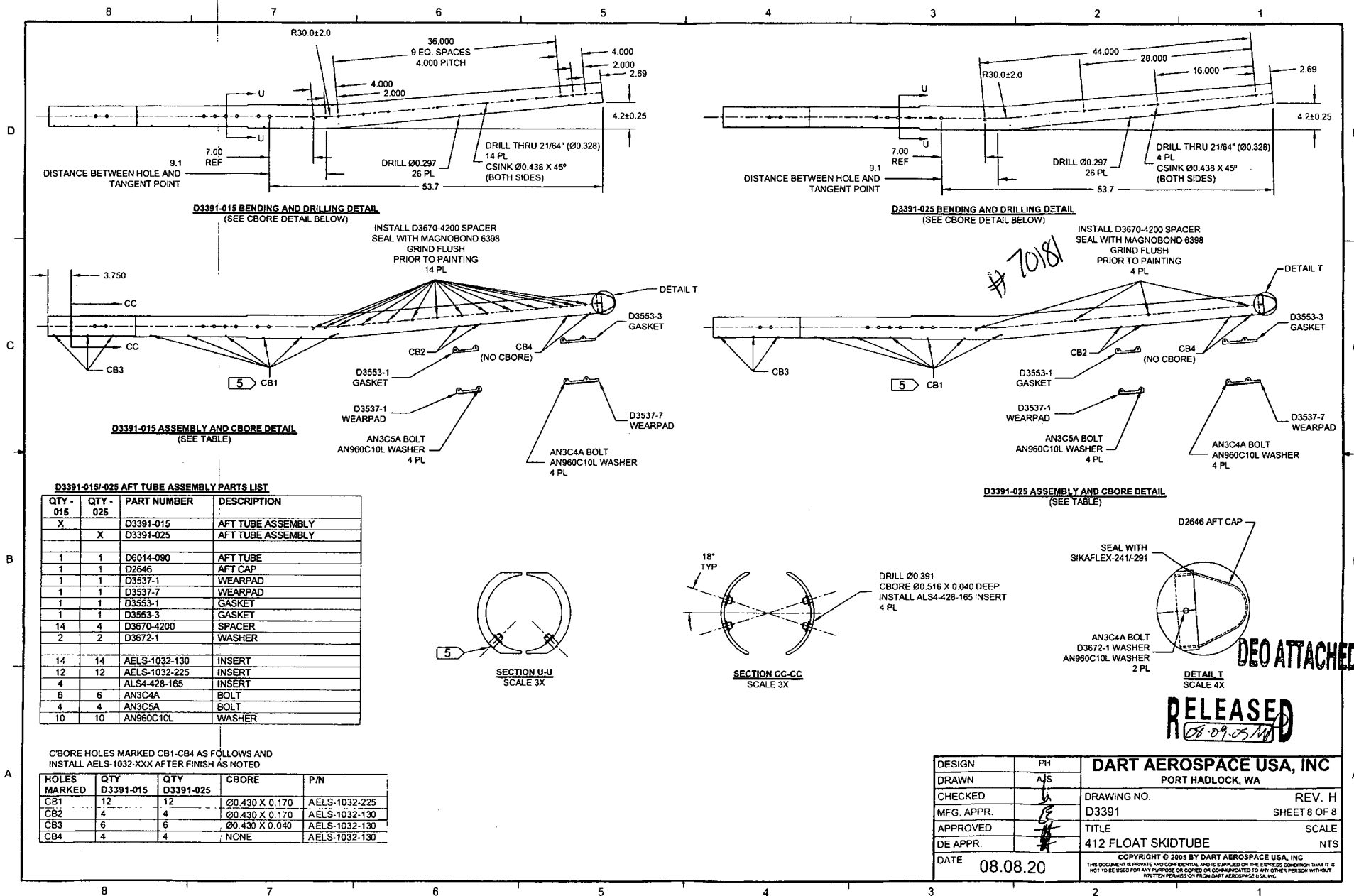
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 04.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02

MP

#70181

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries